

Work Order ID 70714

Monday, June 27, 2011 11:16:29 AM



Page 1

Item ID: D206-642-513

Revision ID:

Item Name: Skidtube LH

Start Date: 6/13/2011 Start Qty: 1.00

Required Date: 6/14/2011 Req'd Qty: 1.00

Reference: RMA RA111217- RETURN- Rework

Approvals: Process Plan:  Date:
QC: Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer: CU-DAR001

Run Start



Stop



Tooling: Date:

SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev L

100



QC

Quality Control

1- Inspect dimensions to dimension sheet

QC

Memo

INSPECT RA111217

0.00

0.00

8/16/13

0.00

0.00

101



HandFinish

Hand Finishing

Memo

-REMOVE AFT CAP AND CLEAN OUT ALL LPS FROM INSIDE &
OUTSIDE OF TUBE
-RE-INSTALL AFT CAP AS PER QSI005
-REMOVE WEARPLATES-REMOVE AND DESTROY/SCRAP ORIGINAL
GASKETS
REPLACE WITH NEW ONES
1 X D3536-15 B 66559
1 X D3536-23 B 66560
1 X D3536-35 B 69755
1 X D3536-39 B 66241
RE-INSTALL ORIGINAL WEARPLATES

DART		TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D206-642-513	CHG	CHG002
DESC	Float Skidtube LH	SIC	SH98-4
LOT	B42292	SIC	SA00475SE
MODEL	Bell 206L/L1/L3/L4/407	SIC	
US PATENT # 5,735,484 CANADA FOREIGN PATENTS PENDING		MADE IN CANADA	

B70714

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Item ID: D206-642-513

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube LH

Start Date: 6/13/2011 Start Qty: 1.00

Required Date: 6/14/2011 Req'd Qty: 1.00

Cust Item ID:

Customer: CU-DAR001

Reference: RMA RA111217

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

110

0.00

Packaging

Memo

0.00

Packaging

REMOVE FROM KITS:
16 X D3672-5 B35521 (RETURN TO STK) ✓
25 X AN3C36A B109771 (RETURN TO STK) ✓ADD TO KITS:
16 X D3672-7 B
35 X AN3C37A B

120

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

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Item ID: D206-642-513

Accept



Setup Start



Revision ID:

Item Name: Skidtube LH

Stop



Start Date: 6/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/14/2011 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA111217

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Memo

0.00

RE-PACKAGE PER PPP USING NEW B/N
NEW PAPERWORK AND LABELS REQ'D

CL 11-7-12
CHG003

11/7/15

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/18

MF
11-07-15

Picklist Print

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Page 1

Work Order ID: 70714

Parent Item: D206-642-513

Parent Item Name: Skidtube LH



Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-10-06 JLM
 IPP Rev:C 07-02-23 As per IIN D206-642 Rev K JLM
 IPP rev D 07.06.06 added K642-513 EC
 IPP Rev:E 07-12-05 ECN 1080p Rev:L DD verified by:
 IPP Rev:F 08-12-09 chg as per DSI9427 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C36A		Purchased	No				Each	133.0000		-25			



BOLT



M/09771

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	
FP-B	31	
111925	31	
ST303	8	
116590	8	
ST353	80	
117125	30	
117872	50	

AN3C37A

Purchased No

Each 107.0000

34



BOLT



11/7/13

Location	Loc Qty	Loc Code
ST353	98	
116874	11	
117010	2	
117763	25	
117885	60	
ST354	9	
117343	9	

11776398
 117885204

Picklist Print

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Work Order ID: 70714

Parent Item: D206-642-513

Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D206-642-513 Manufactured No

Each 0.0000



1 42292

[Handwritten signature]

Skidtube LH

D3536-15 Manufactured No

Each 17.0000



1

u 1106130

Gasket

Location

Loc Qty

Loc Code

FP011

17

66559

17

xl

D3536-23 Manufactured No

Each 36.0000



1

u 1109130

Gasket

Location

Loc Qty

Loc Code

FP011

36

43406

1

66560

9

69902

26

xl

D3536-35 Manufactured No

Each 24.0000



1

u 1109130

Gasket

Location

Loc Qty

Loc Code

FP012

24

69755

24

xl

D3536-39 Manufactured ~~No~~

Each 35.0000



1

u 1109130

Gasket

Location

Loc Qty

Loc Code

FP015

35

66241

9

69760

26

xl

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 70714



Parent Item: D206-642-513



Parent Item Name: Skidtube LH

Start Date: 6/13/2011

Required Date: 6/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-5

Manufactured No

Each

1,832.000

-16



Phenolic Washer



35521 6/14/13

Location

Loc Qty

Loc Code

ST074

1832

35521

1043

44679

220

50354

569

D3672-7

Manufactured No

Each

850.0000

16



Phenolic Washer



6/14/13

Location

Loc Qty

Loc Code

ST074

850

53237

244

64175

606

64175

Monday, June 27, 2011 11:16:26 AM

Shop Packet Print

Page 3

DART Aerospace Ltd

CUSTOMER RETURN

#RA: 111217
Date: MAY 3, 2011Initiator: M. BELLAVANCE
Company: UNITED ROTORCRAFT
Contact: JOHN GRISHAM
Phone No.: 1 845 627 0626Invoice #: INV104624
SO#: SO104660Attach Copy of DHS Return Authorization #: 00964

SQ#: _____ NCR#: _____ CSR#: _____ PAR#: _____

Reason for Return:

SEE ATTACHED

Receiving:

Date Received: 11/6/13 Freight Company: DAY R-S-S Prepaid Collect

Qty	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
<u>1</u>	<u>D206-642-513</u>	<u>B42292</u>	<u>SHITUBE</u>		
	<u>SLY</u>	<u>B42293</u>			

Condition of Packaging: BOITE DAMAGEE Photograph Required: yes noPaperwork Attached: P/S _____ Invoice X penals ARC _____ Docs _____ Other _____

QC:

Quarantine Location: QC Quarantine Condition of Part: Sealed / Accepted / Damaged / ScrapInspectors Initial: S Date: 11/6/13 Photograph Required: yes no

Qty	Part #	CHG #	Batch #	QC Comments	QC Approval		Scrap
					Initial	W/O#	
	<u>D206-642-513</u>	<u>002</u>	<u>42292</u>	<u>see Attached instruction sheet</u>	<u>A</u>	<u>10714</u>	
	<u>D206-642-514</u>	<u>002</u>	<u>42293</u>	<u>see Attached instruction sheet</u>	<u>L</u>	<u>10715</u>	

QA Coordinator:

Advise GM as to Findings: Initial: JA Date: 11/06/13

Comments:

Issue Credit: yes noCNINV105301 11/06/13GM Approval: MADate: 11/06/13Invoice Amount: _____
Less Replacement: _____
Restock Fee: _____
Freight: \$ _____
Net Credit: 15,625.80
DHS Customer

QA: Enter into Q-Pulse with Reason for Return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit

RA 111217 D206-642-513 B42292

Instructions to put skid tube back in to stock

- Remove Aft cap and clean out all LPS on the inside and outside of the tube and reinstall aft cap as per QSI 005
- Remove and scrap original rubber gaskets and install new ones

To Bring Skid tube to CHG003 this is needed

- Remove D3672-5 B35521 QTY 16 from kit and put back into stock
- Remove QTY 25 AN3C36A M109771 from kit and put back into stock
- Add QTY 16 D3672-7 B/M# _____ to kit
- Add AN3C37A M# _____ QTY 34 to kit
- Needs new **BATCH #** to be put back into stock under
- Needs new paper work

RA 111217 D206-642-514 B42293

Instructions to put skid tube back in to stock

- Remove Aft cap and clean out all LPS on the inside and outside of the tube and reinstall aft cap as per QSI 005
- Remove and scrap original rubber gaskets and install new ones

To Bring Skid tube to CHG003 this is needed

- Remove D3672-5 B35521 QTY 16 from kit and put back into stock
- Remove QTY 25 AN3C36A M109771 from kit and put back into stock
- Add QTY 16 D3672-7 B/M# _____ to kit
- Add AN3C37A M# _____ QTY 34 to kit
- Needs new **BATCH #** to be put back into stock under
- Needs new paper work

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

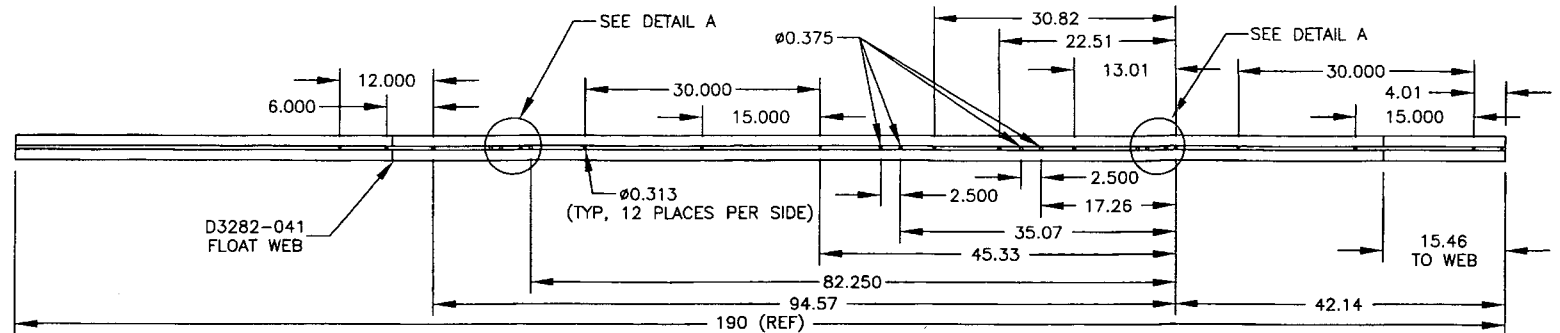
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

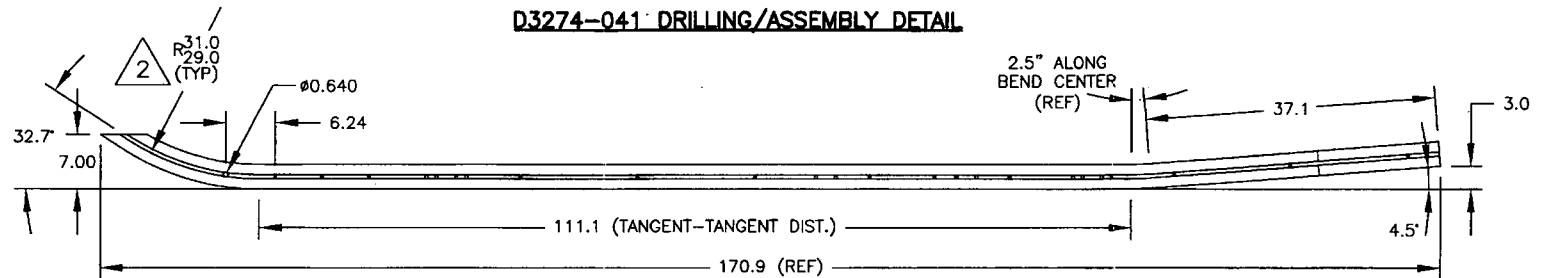
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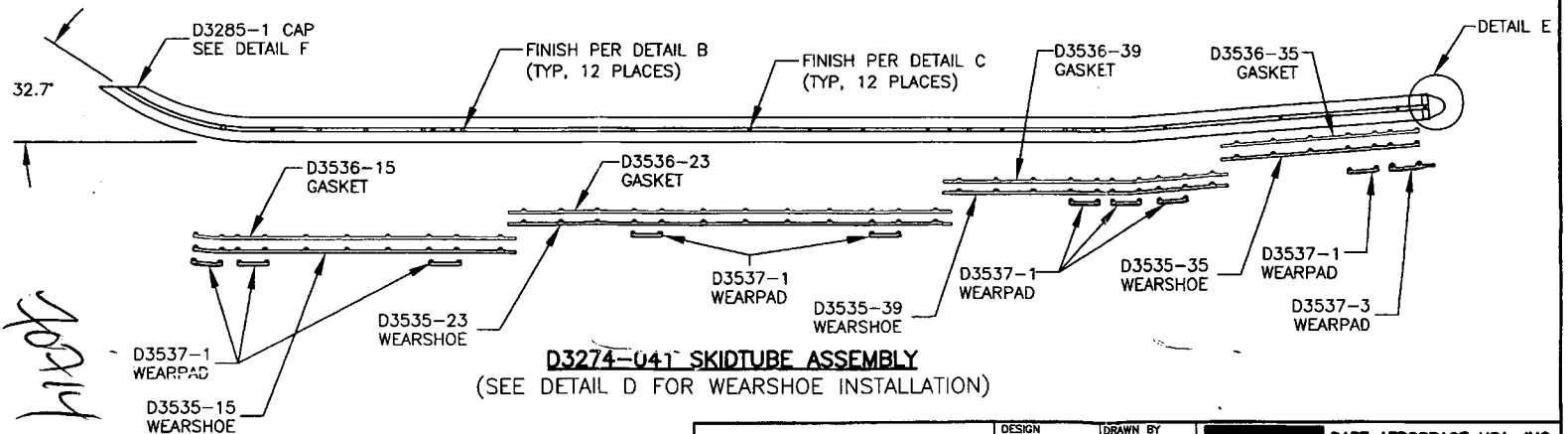
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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07.02.12

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DESIGN

CP

DRAWN BY

PH

DART DART AEROSPACE USA, INC.

PORT HADLOCK, MA

CHECKED

APPROVED

DRAWING NO.

D3274

REV. D

DATE

06.12.19

TITLE

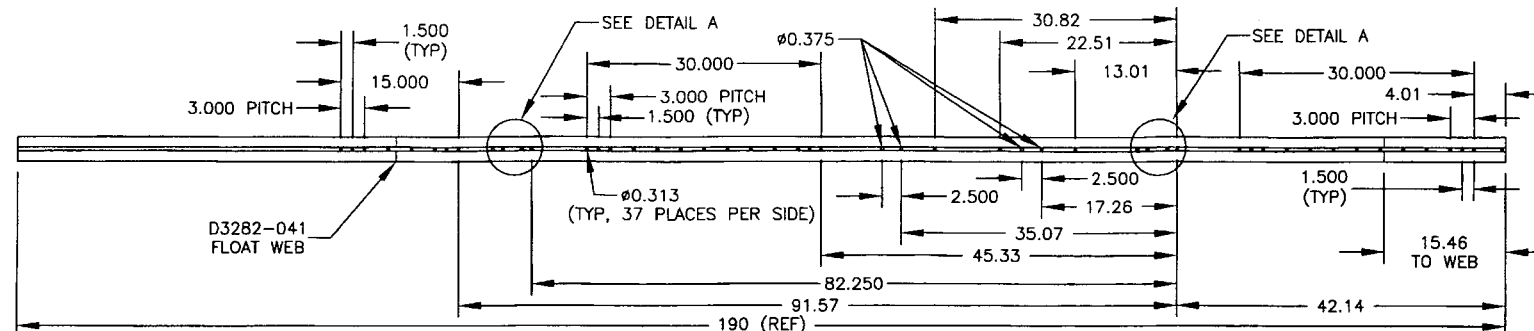
SKIDTUBE ASSEMBLY

SHEET 2 OF 4

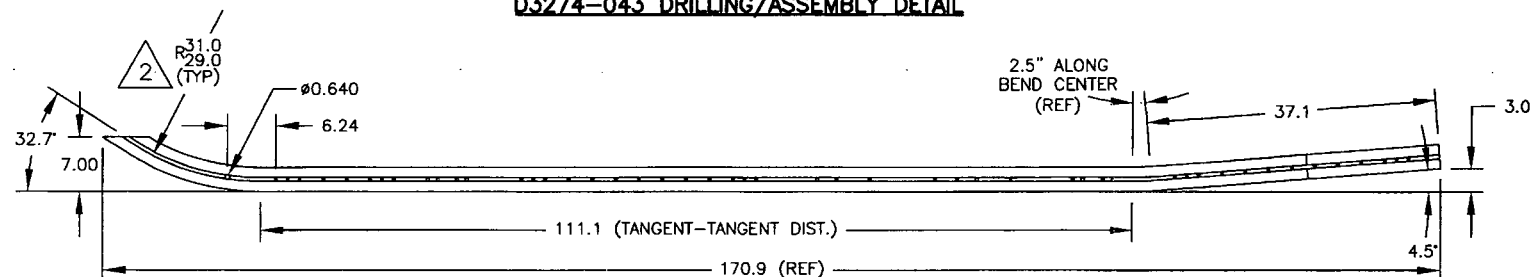
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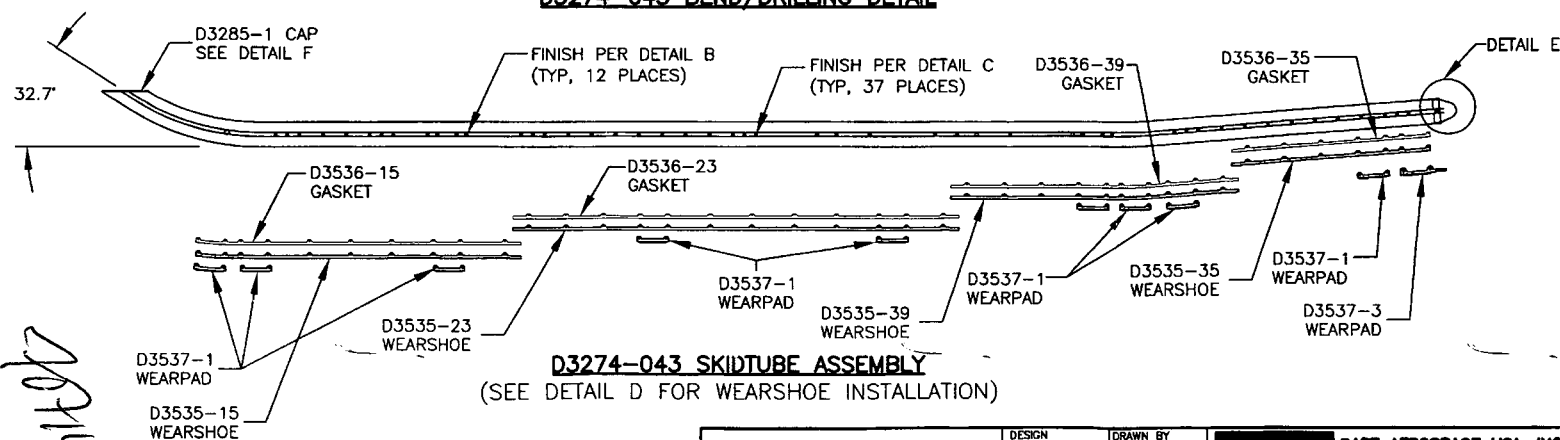
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

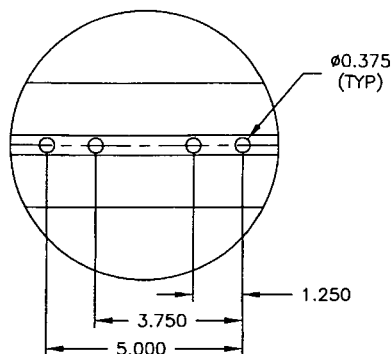
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07-02-12

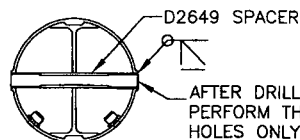
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CHECKED	APPROVED	CP	PH	DRAWING NO.	REV. D
				D3274	SHEET 3 OF 4
DATE				TITLE	SCALE
06.12.19				SKIDTUBE ASSEMBLY	1:15

DETAIL A: DRILL DETAIL

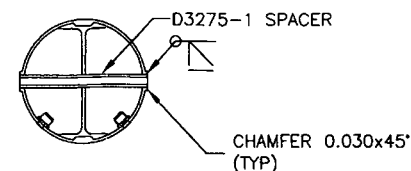


DETAIL B FOR 0.375 HOLES ONLY

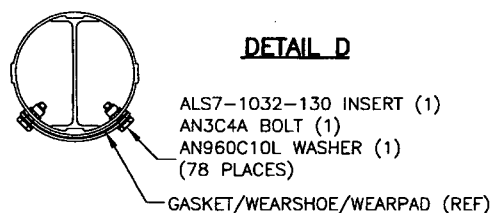


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

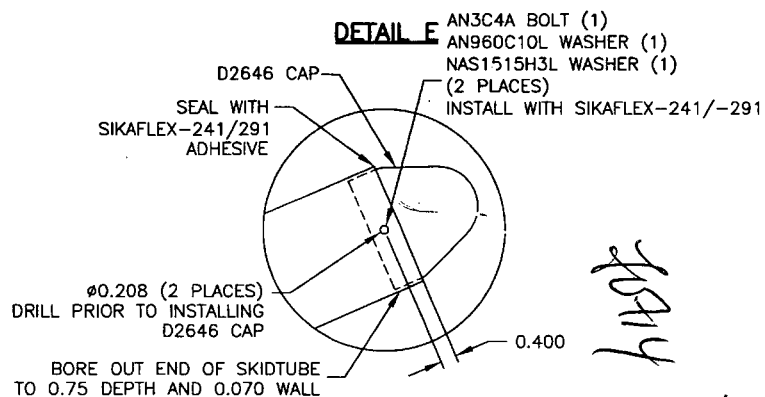
DETAIL C FOR 0.313 HOLES ONLY



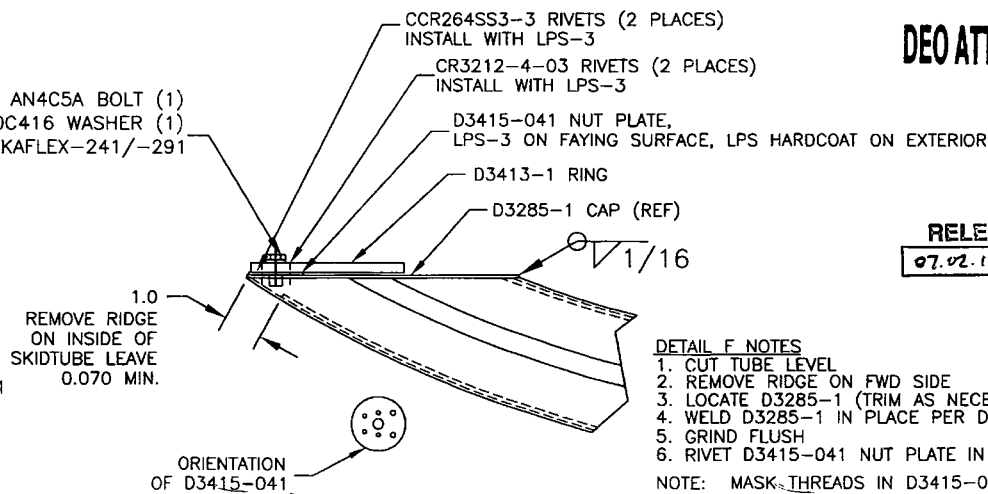
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED

07.02.12

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DATE	06.12.19	D3274		SHEET 4 OF 4	SCALE
TITLE				SKIDTUBE ASSEMBLY	

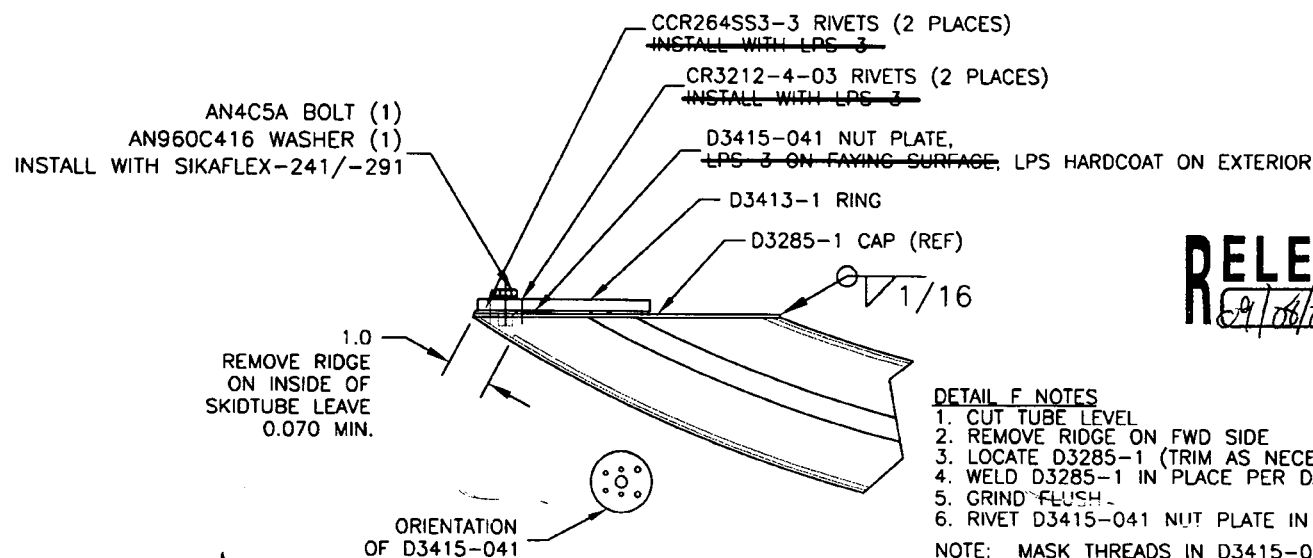
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
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